# COST and MANAGEMENT

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# THE CANADIAN SOCIETY OF COST ACCOUNTANTS & INDUSTRIAL ENGINEERS

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# Costing in the Boot and Shoe Industry

N response to a questionnaire issued by our Society in July, several Canadian manufacturers of boots and shoes have been kind enough to submit specimens of the forms used in connection with their costs, with in some cases accompanying comment on their accounting methods. The costing practices are far from uniform in the industry, but are often similar so far as the more common or essential operations are concerned. Replies were not complete enough to form a basis for any comprehensive summary, but they do make it possible to indicate some of the alternative methods in use. Those reproduced herewith have been selected so as to give as representative a picture as possible, of costing practices in the industry. Some replies not published merely duplicate these methods in the main. The forms reproduced are of course condensed in size for purposes of reprinting.

### COMPANY A

This company's form (Form A1) was submitted without comment, and is reproduced as a typical cost sheet.

### COMPANY B

"As requested, we are enclosing a cost sheet form (See Form B1) as used by our company, and find that we get the desired results if the sheet is used for what it is intended. In a few words, I will try to explain the make up of this sheet.

"In the cutting department, each pattern is measured in inches. You will note that the vamp measurement is 66% square inches. In black kid our waste allowance is 25% which is added to the pattern measurement, and extended in square feet, which is .58 of a foot. Our cost sheets are figured in 30 pairs, which means that the first item on the sheet is .58 x 30 pairs x the price of the leather, which 30% per foot, making a total of \$5.307. All parts that are cut from kid are figured out the same way. The tip which is black calf, is given an allowance of 18%, cotton lining allowance 10%, kid quarter linings 15%. (In reproducing this form, actual figures have been omitted.)

"In the sole leather department, nearly all parts are purchased ready cut, which is based on the price laid down.

"Supplies and findings are actually weighed and measured with a 2% waste allowance. Labor is all piece work, which gives a true labor cost. The total being 91.156, divided by 30 pairs, gives the price per pair."

### COMPANY C

"The cost sheet (Form C1) enclosed is the form we use when arriving at cost of our product. We will endeavour to break this down, and explain how different quantities and prices are arrived at. All prices are figured in our costs per hundred pair. Our labour piece prices the same.

"The space marked 1A is used to arrive at cost of upper stock used in 100 pair of shoes. For quantity of upper leather outsides and linings, we use the Krippendorf Kalculator system. In using this system the pattern parts of each model are sent away, and this company surveys them sending us reports showing the exact amount

of any leather necessary to cut any particular part. This system enables us to have exact figures as tto cost of any leather necessary for any kind of shoe.

"The space marked 1B is used to figure cost of sole leather and

parts of the bottom of shoe.
"The supplies and findings space marked 1C is used to arrive at cost of miscellaneous small materials that are used in a shoe, and that stay in a shoe when finished, such as laces, eyelets, thread, cements, etc. This figure is arrived at by averaging cost per pair used in this account from previous years. It is necessary to fix an arbitrary figure because there are so many miscellaneous items charged against this account that it would not be possible to estimate amount used in any particular shoe or pattern.

"1D column is used to figure labour cost. Each different pattern is figured separately. In cutting department, the Richardson System of cutting prices is used. This system allows a certain amount for each stroke of cutter's knife used in cutting any pattern. The fitting price is figured on each pattern by the foreman of the department

with help of comparative figures given by this office.

"All labour prices for other departments are set from total of actual piece work rates paid. These do not fluctuate as same operations are done in these departments on all shoes with few exceptions, which may be taken into consideration when setting these prices.

"A weekly report is given each foreman showing the loss or gain made on these actual labour cost figures. Copy of this report en-

closed. (Form C2).
"A comparative is also kept for office use on the Departmental Production record copy of which is enclosed. (Form C3.) This is a very useful form.

"Space marked 1E. The figure for Royalty is on actual figure arrived at by cost of royalties paid for different machines, processes

and patents.

'Cartons and cases is figure taken from comparative per pair cost of this account from previous years. Cartons and cases include cost of shoe boxes, shoe containers and all materials used in shipping.

"Manufacturing Expense is an account against which all items used on shoes, but which are not found in finished product are charged, such as abrasives, rubbers, tacks, etc. which are used in making, but afterwards withdrawn. The figure used in cost is also taken from comparative cost of previous years for the particular type of shoe

being costed.

Space marked 1F. No. 2 stock account is an account against which is charged all factory seconds, cancellations, and returned shoes. An allowance per pair is set up in this cost which is credited to this account, and cost of disposing (or loss taken) is charged against this account. The figure or allowance used in this cost is taken from comparative statements showing previous record of this account. The loss or gain in this account shows to certain extent of plant and also whether goods good or bad shoes are being made. If good, there are few charges against it and it will show profit, and vice versa.

"L. D. & P. is the Last, Dies and Pattern account. This amount is set up in cost from comparative from previous years. This is also a

loss and gain account.

"Administrative overhead. At the beginning of every year we budget to arrive at this figure. This budget includes all administrative (including superintendent, foremen, plant and office salaries); miscellaneous expense which includes telephone, telegraph, postage,

stationery, credits and collections, interest and exchange, audit, insurance, taxes and travelling expense accounts; selling expense which includes advertising, general selling expense, freight out, sample loss, complimentary sales and donation accounts; miscellaneous which includes factory expense, machine parts, light, heat and power, machine rentals, depreciation reserve, and freight and express in. This budget for these accounts is figured from previous experience of previous years, and our knowledge of business conditions and expectations of sales.

"These different figures give us the cost of the shoe.

"So that our figures, budgeted and otherwise do not get out of hand, we take off monthly statements. Quartery, we take physical

stock taking of our whole organization.

"You will have noted that we have report on labour figures which if not according to costs can be corrected. In addition, we take off monthly comparative statements of the following: All loss and gain accounts, record pairage received from each salesman, salary analysis, working capital, manufacturing & trading account, overhead control and inventories: From these, we know that we are meeting our budgeted figures, which tie in with our actual costs of shoes. If they do not, our selling price may be lowered or raised to take care of difference if it cannot be corrected in the factory."

### COMPANY D

We attach the various forms:

1. Cutting check.

Cutting department piece work prices.
 Fitting department piece work prices.

- Lasting department and making department piece work prices.
- prices.
  5. Finishing department piece work prices.
  6. Recap of departments plus time labour.

7. Cost sheet.

"Cutting check. Form D1: One of these forms is made out by foreman in the cutting room for every case going through the factory. This is an estimate of upper material used, and is compared with estimate on cost sheet. It is also used when samples are going through. The foreman of the cutting room fills in the estimate of upper stock that the pattern will require, and also at the bottom the piece work prices.

"Cutting Department, Form D2: The cutting room foreman fills in piece work prices on this slip. He keeps copy and original

goes to office of every sample.

"Fitting Department. Form D3: This sheet is filled in by forelady of fitting room. She keeps copy for her own record, and original goes to office.

"Lasting & Making Department Piece Work Prices. Form D4: The foreman of lasting and making room makes out this form, keeps

one copy, and original goes to office.

"Finishing Department Piece Work Prices. Form D5: The foreman of this room fills in this form, keeps copy and original goes to

office.

"Recap of Departments' Piece Work Prices. Form D6; When sheets #2, 3, 4, 5, are sent to office, they are added, then checked. The average time or day work is added to each department except fitting. The fitting department piece work prices are not as standard as in other departments, but change with patterns. For that reason there is more time work in the fitting room, and is very hard to dis-

tribute. The fitting department costs are not figured with piece work, plus time or day labour, but more a comparison and consideration of piece work, and the operations that are done on time or day labour, but not an average time or day labour charge. From this sheet the labour costs are carried to the cost sheet, except as we said before, the fitting department, and this would be put in at say .20c per pair, or .30c per pair. This figure would depend on the pattern. Piece work prices have been established from year to year. We have never used a time study. We believe our piece work prices compare favor-

ably with other factories in this district.
"Cost Sheet. Form D7: From quarter to goring we consider cutting. In other words, the cutting room foreman takes from his stock all these requirements and when case is cut, all this material goes with the case to the fitting room. Trimming to gum tape, fitting department material, sole department, outsole to cookie, lasting department, counter to lasting tacks, making department, filler to cement, finishing department, embossing leaf to cartons, cases. Then comes total of cutting and fitting, sole, lasting, making, and finishing. Then material and labour costs, which is piece and time, or day labour. Then material and labour costs are added, plus percentage, whatever one's overhead is. This is added to total material and total labor cost, plus overhead. This net space is used for a number of things. We use one percentage, included losses, and selling expenses."

(Forms are illustrated pages 262-276)

# REFERENCE LITERATURE

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August 17.

Budgeting in Industry. Accountants' Journal, August. Agricultural Accounting, Some Aspects of. Canadian Chartered Accountant, August

Budgetary Control. The Cost Accountant, August.

"Drink," said the Irish preacher, "is the greatest curse of the country. It makes yer quarrel with yer neighbors. It makes yer shoot at yer landlord; and it makes yer miss him.

### Form A1

		Quantity	Price	Price	Price	Price
Tops		Ft.				
Outsides		Ft.				
Bel Tongue		Ft.				
Counter Lining						
Top Facing		F't.				
Side Facing		Ft.				
Back Stay						
Cutting						
Top Band		Yds.				
Fitting						
Outsole	Ga.	60 Pr.	%			
Slipsole	Ga.	60 Pr.	%			
Shank Filling		Lbs.	%			
Insole		60 Pr.	%			
Heel		60 Pr.				
Top Price Stock Fitting		Lbs.	%			
Counters		60 Pr.				
Lasting						
Bottoming						
Sock Lining		Yds.	,			
Cartons		60 No.				
Cases		No.				
Packing						
Findings						
Royalty		_				
_	otal					
% Overhe	ad					
Cost 60 Pairs		_				
Cost 1 Pair						
% Profit		_				
Selling Price						
-						

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HEEL   SOLE   TIP   LAST     Vamp   Vamp   Foxing     Vamp   Vamp   Foxing     Quarter   Counter     Tongue   Lining     Vamp   Counter     Tongue   Lining     Vamp   Lining   Faper     Vamp   Lining   Faper     Vamp   Lining   Faper     Vamp   Lining   Faper     Vamp   Lining   Lining     Vamp	VAMP
	LAST DATE STOCK No.
	Amt. Brought Forward
	IES:
	ets
	ks
	Lace Hung Noils and Colles
	Coke Oven Clamps
	Heel and Toeplates
	T,
	H
	Caper
	ous and cases
	End Labels
	Notal Supplies Cost
	Merchandise Findings
	Fotal Material Cost
	Manufacturing Expense
	eii.
	Stitching
	Stock Fitting
	Lasting
	Bottoming
	Finishing
	Packing
	Total Labor Cost
	Motol Cont
	Deige Lost
Discount	nt
	Net
Total Bottom Cost Profit	

# FORM C1 COST SHEET

And Grade Quant, Frice Amount SOLE Kind Gus Outsoles Insoles Slip Soles Slip Soles Slip Soles Slip Soles Box Toes Heels Top Pieces Heels Top Pieces Lea. Lift Welting Welting Welting St. Ernbings Labour Fitting Fitting Fitting Soles Soles Soles Soles Labour ID Wood Heel ID		
Stay  Stay  In Stay	Guage Grade Quant. Price Amt.	RECAPITULATION
ay IA Filler Counters Box Toes Heels Top Pieces Lea. Lift Welting Dutchman  Total  ES & FINDINGS Cutting Fitting Cutting Fitting Cutting Fitting Lasting Lasti		Upper Stock Sole " Supplies and Findings Labour Sundries
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© FINDINGS  Cutting Fitting Cutching Cutouts Sole Stock Lasting Lasting Dacking IC Wood Heel ID		Total Cost
& FINDINGS LABOUR Cutting Fitting Cutouts Sole Stock Lasting Wood Heel ID	Total	
pt. Cutting Fritting Cutouts Sole Stock Lasting Wood Heel ID	SUNDRIES	
French Cord Coodyear Conaments Finishing Freeing & Packing Cement Total Total	Royalties Cartons & Cases Mfg. Exp. IE	

### FORM C2

# LABOUR COST W/E

Upper L Sole Cripples Damaged Charges Charges	cather Cripples  Charged d shoes prs.
	Wagesprs. @Loss or Gain
Fitting V	Wages prs. @ Loss or Gain
Sole Lea	ther Wages pr. @ 3. 0 prs. Welts @ 4.10 prs. Wedging heels @ 1c prs. Lockwedge @ 6%c Loss or Gain
Lasting 1	Dept. Wages Littleways @ 12c Welts @ 8%4c Childs @ 6½c Loss or Gain
Heeling V	Wages Littleways @ 4½ Welts @ 4½c Loss or Gain
Welting	Wages prs. @ 9c prs. Childs @ 7c Loss or Gain
Finishing	Wages Lea heels @ 13½c Wood heels @ 8½c Childs @ 8c Loss or Gain
Treeing &	& Packing Wages prs. @ 8½c
	Cant, Childs & Misses @ 7%c  Loss or Gain  Total Losses Inspection Total Gains  Net
	Net

# FORM C3

# DEPARTMENTAL PRODUCTION AND LABOUR COST RECORD

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Day	Date	No.	Sheet	Carring	FILLING	Sole Stock	Tooling	Bosning	Goodyear	r inisning	I Lege	Lack	Suidding	ipments
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Wed	nesda	A					ent t.	Cay	t.	er s t. ther				

Saturday Thursday Tuesday Friday Wedne

Fotal Working Days to Date Average Daily Production to Total Production for Week Average Daily Production Total Production to Date Date Sub-Totals

Total Pairs in Process in Total Pairs Finished by Department Department Department

Total Pairs Received by

Labor Cost per Pair for Week Total Wages to Date Average Labor Cost per Pair to Date Total Wages for Week

### FORM D1

### CUTTING CHECK

Stock Given Out	Estimate
Vamp Quarter Trimming Stock Quarter Lining Heel Covers  Backing Stadfast White "Black Goring	
PIECEWORK PRICES	
Oper. No. 147	

### CUTTING DEPARTMENT

Samp	le	Pat	tern						I	a	te									
Descr	iption	1																		_
			Price														F	r	ic	e
Op.#	2 Se 3 Di 4 Ba	tting outsides cond cutting out eing out al cloth linings	Ор.#	9 10	L	ini ini	ng	s,	1	001	or ng	d	e e	2	par	oi	1			
	6 Va 7 Ba	oth linings, oxford, raps and pomps imp backers il, and lace stay	• • • • • • • • • • • • • • • • • • • •	• • •	• •	• • •		• •	• •											
	8 Le	ather linings, strap																		

### FORM D3

### FITTING DEPARTMENT

Date	Sample			Model	
Op. No. Price Op. No. Price  1 Inking	Date			Pattern	
1 Inking 2 Marking 3 Marking 3 Making linings 4 Skive blucher straps 5 Closing blucher tie linings 6 Staying linings 7-a Reinforce linings 7-a Reinforce cut-outs 7-b Reinforce back seam 7-c Reinforce tongues 7-0 Reinforce tongues 8 Skiving sample no. 9 Closing sample no. 9 Closing sample no. 9 Closing sample no. 10 Staying sample no. 11 Rubbing seam 12 Clip edge 12-a Clip edge 13 Fold quarters 14 Fold vamps 15 Fold straps 15 Fold straps 16 Fold foxings 17 Fold tip 18 Fold tongue 19 Fold saddle 20 Perforate quarters 21 Perforate typer 22 Perforate straps 23 Perforate disps 24 Stitch saddle 25 Under or overlay on 25 Stitch tongue 26 Stitch cut-outs 27 Vamp 28 Unit out-outs 29 Vamp pomps 20 Undertrim and 20 edgestitch 21 Undertrim blucher 22 Undertrim blucher 23 Eyeletting 24 Lining tongues 25 Stitch tongue to 26 Stitch tongue to 27 Lacing 28 Barring 29 Parforate dips 29 Parforated foxings 21 Perforate dyamps 22 Stitch perforated dyarters 23 Stitch perforated dyarters 24 Stitch quarters 25 Stitch perforated dyarters 26 Stitch perforated tips 27 Stitch perforated tips 28 Paste stickers 29 Paste stickers 30 Binding 31 Stitch tips	Description				
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7-b Reinforce back seam 7-c Reinforce tongues 7-0 Reinforce upper 8 Skiving sample no. 9-a Closing foxing 9-b Closing vamp 10 Staying sample no. 11 Rubbing seam 12 Clip edge 13 Fold quarters 14 Fold vamp 15 Fold straps 15 Fold straps 16 Fold foxings 17 Fold tip 18 Fold tongue 19 Fold saddle 20 Perforate quarters 21 Perforate vamps 22 Perforate straps 23 Perforate foxing 25 Stitch perforated duamps 27 Stitch perforated dumps 28 Stitch perforated dips 29 Paste stickers 20 Binding 20 Stitch quarters 21 Binding 22 Stitch tips 23 Stitch vamps 24 Stitch foxing 25 Stitch toxing 26 Stitch vamps 27 Stitch quarters 28 Stitch quarters 29 Stitch quarters 30 Stitch vamps 31 Stitch vamps 32 Stitch foxing 35 Stitch tips			43	Stich die cut-outs	
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7-0 Reinforce upper 8 Skiving sample no. 9 Closing sample no. 9-a Closing foxing 9-b Closing yamp 10 Staying sample no. 11 Rubbing seam 12 Clip edge 12-a Clip edge 13 Fold quarters 14 Fold vamps 15 Fold straps 16 Fold foxings 17 Fold tip 18 Fold tongue 19 Fold saddle 20 Perforate quarters 21 Perforate trips 22 Perforate foxing 24 Perforated quarters 25 Stitch perforated quarters 26 Stitch perforated tips 27 Paste stickers 28 Binding 29 Stitch quarters 30 Binding 32 Stitch toxing 35 Stitch toxing 35 Stitch toxing 36 Stitch toxing 37 Stitch foxing 38 Stitch foxing 39 Stitch foxing 30 Stitch tips 31 Stitch foxing 35 Stitch tips 36 Undertrim and edgestitch 49 Undertrim oxfords 50 Undertrim blucher 50 Vundertrim blucher 51 Undertrim bals 52 Undertrim blucher 53 Eyeletting 54 Lining tongues 55 Toe seaming 55 Toe seaming 56 Stitch tongue to lining 57 Lacing 58 Barring 59 Hand Trimming 60 Cement cushion soles 61 Bind cushion soles 62 Stitch covers 63 Turn french cord 63-a Turn french cord 74 Wamp blucher oxfords 8 Undertrim and 64 edgestitch 9-4 Undertrim and 64 Sundertrim and 64 Sundertrim oxfords 9-5 Undertrim blucher 75 Undertrim blu					
8 Skiving sample no. 9 Closing sample no. 9-a Closing foxing 9-b Closing vamp 10 Staying sample no. 11 Rubbing seam 11 Clip edge 12-a Clip edge 12-a Clip edge 13 Fold quarters 14 Fold vamps 15 Fold straps 16 Fold foxings 17 Fold tip 18 Fold tongue 19 Fold saddle 20 Perforate quarters 21 Perforate tips 22 Perforate tips 23 Perforate tips 25 Stitch perforated quarters 26 Stitch perforated tips 27 Paste strickers 28 Binding 29 Stitch quarters 30 Binding 32 Stitch vamps 35 Undertrim blucher 20 Auffording blucher 20 Vamp 21 Undertrim blucher 20 Vamp 21 Luning tongues 24 Lining tongues 25 Stitch tongue 26 Stitch tongue 27 Lacing 28 Barring 29 Hand Trimming 20 Cement cushion soles 20 Perforate dips 21 Perforate vamps 22 Stitch perforated quarters 23 Stitch perforated foxings 24 Perforate tips 25 Stitch perforated toxings 26 Machine cut outs 27 August outs 28 Stitch quarters 39 Binding 30 Stitch vamps 30 Stitch tips 30 Stitch tips 31 Stitch tips			46	Vamp pomps	
9 Closing sample no. 9-a Closing foxing 9-b Closing yamp 10 Staying sample no. 11 Rubbing seam 11 Rubbing seam 12 Clip edge 13 Fold quarters 13 Fold quarters 15 Fold straps 16 Fold foxings 17 Fold tip 18 Fold tongue 19 Fold saddle 19 Fold saddle 19 Perforate quarters 19 Perforate vamps 10 Perforate foxing 10 Perforate dips 11 Perforated tips 12 Stitch perforated tips 13 Fold parters 14 Rubbing seam 15 Undertrim blucher 15 Eyeletting 16 Fold straps 17 Fold straps 18 Fold tongue 19 Fold saddle 10 Perforate vamps 10 Cement cushion soles 10 Perforate foxing 11 Fold tip 12 Perforate foxing 13 Fold tongue 14 Perforated tips 15 Fold tongue 16 Fold tongue 17 Fold tip 18 Fold tongue 19 Fold saddle 19 Fold saddle 20 Perforate vamps 21 Perforate vamps 22 Perforate foxing 23 Stitch perforated foxings 24 Perforated tips 25 Stitch perforated tips 26 Stitch perforated tips 27 Stitch perforated tips 28 Stitch perforated tips 29 Paste stickers 20 Binding 20 Stitch quarters 21 Binding 22 Stitch quarters 23 Stitch vamps 24 Stitch foxing 25 Stitch tips 26 Stitch tips 27 Fold tip 28 Fold tongue 29 Paste stickers 20 Binding 20 Stitch quarters 20 Stitch quarters 21 Fold tongue 22 Forforated tips 23 Stitch perforated tips 24 Perforated tips 25 Stitch perforated tips 26 Stitch perforated tips 27 Fold tip 28 Fold tongue 29 Perforate tips 20 Perforated tips 20 Perforated tips 21 Perforated tips 22 Stitch perforated tips 23 Stitch perforated tips 24 Perforated tips 25 Stitch perforated tips 26 Stitch perforated tips 27 Fold tip 28 Fold tongue 29 Perforate tip 20 Perforate tip 20 Perforate tip 21 Perforated tips 22 Stitch perforated tips 23 Stitch perforated tips 24 Perforate tips 25 Stitch perforated tips 26 Stitch perforated tips 27 Perforate tips 28 Stitch perforated tips 29 Perforate tips 20 Perforate tips 20 Perforate tips 20 Perforate tips 21 Perforate tips 22 Perforate tips 23 Stitch perforated tips 24 Perforate tips 25 Stitch perforated tips 26 Stitch perforated tips 27 Perforate tips 28 Stitch perforated tips 29 Perforate tips 20					
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12-a Clip edge vamp 13 Fold quarters 53 Eyeletting 14 Fold vamps 54 Lining tongues 15 Fold straps 55 Toe seaming 16 Fold foxings 56 Stitch tongue to 17 Fold tip lining 18 Fold tongue 57 Lacing 19 Fold saddle 58 Barring 20 Perforate quarters 59 Hand Trimming 21 Perforate vamps 60 Cement cushion soles 22 Perforate straps 61 Bind cushion soles 23 Perforate tips 63 Turn french cord 25 Stitch perforated quarters 26 Stitch perforated quarters 27 Stitch perforated tips 64 Machine cut outs 28 Stitch perforated tips 65 Button holes 29 Paste stickers 65 Button holes 30 Binding vamps 66 Sew buttons 31 Binding 32 Stitch quarters 33 Stitch vamps 55 Stitch tips			52	Undertrim blucher	
14 Fold vamps 54 Lining tongues 55 Fold straps 55 Toe seaming 56 Stitch tongue to 17 Fold tip 1 lining 18 Fold tongue 57 Lacing 58 Barring 59 Hand Trimming 60 Cement cushion soles 60 Cement cushion soles 60 Cement cushion soles 61 Bind cushion soles 62 Perforate traps 61 Bind cushion soles 62 Stitch perforated quarters 63 Turn french cord 63 Turn french cord 64 Stitch perforated tong 65 Stitch perforated tips 66 Turn french cord 67 Vamp 66 Stitch perforated tips 67 Binding 68 Stitch perforated tips 68 Barring 69 Stitch perforated forms 69 Stitch perforated forms 69 Stitch perforated tips 69 Binding vamps 60 Sew buttons 60 Sew bu				vamp	
15 Fold straps 16 Fold foxings 17 Fold tip 18 Fold tongue 19 Fold saddle 20 Perforate quarters 21 Perforate vamps 22 Perforate straps 23 Perforate foxing 25 Stitch perforated quarters 26 Stitch perforated quarters 27 Stitch perforated foxings 28 Stitch perforated tips 29 Paste stickers 30 Binding 32 Stitch quarters 33 Stitch vamps 34 Stitch foxing 35 Stitch tips 36 Stitch tips 37 Stitch foxing 38 Stitch vamps 39 Stitch quarters 30 Stitch quarters 31 Stitch quarters 32 Stitch foxing 33 Stitch foxing 35 Stitch tips	13 Fold quarters		53	Eyeletting	
16 Fold foxings 56 Stitch tongue to lining 18 Fold tongue 57 Lacing 59 Fold saddle 58 Barring 20 Perforate quarters 59 Hand Trimming 21 Perforate straps 60 Cement cushion soles 22 Perforate straps 61 Bind cushion soles 23 Perforate tips 62 Stitch covers 63 Turn french cord 25 Stitch perforated quarters 26 Stitch perforated toxings 27 Stitch perforated tips 64 Machine cut outs 28 Stitch perforated tips 65 Button holes 65 Button holes 65 Button holes 65 Stitch quarters 65 Stitch quarters 65 Stitch quarters 65 Stitch toxing 65 Sti					
17 Fold tip					
18 Fold tongue 57 Lacing 58 Barring 59 Portorate quarters 59 Hand Trimming 59 Perforate vamps 60 Cement cushion soles 59 Perforate straps 61 Bind cushion soles 62 Stitch covers 63 Turn french cord 63 Turn french cord 70 Vamp 64 Machine cut outs 70 Administration of 65 Button holes 70 Binding 70 Stitch quarters 70 Stitch quarters 70 Binding 70 Stitch quarters 70 Stitch quarters 70 Stitch quarters 70 Stitch quarters 70 Stitch foxing 70 Stitch tips 70 Stitch tips 70 Stitch quarters 70 Stitch foxing 70 Stitch tips 70 Stitch quarters 70 Stitch foxing 70 Stitch tips 70 Stitch quarters 70 Stitch tips 70 Stitch quarters 70 Stitch foxing 70 Stitch tips 70 Stitch quarters 70 Stitch quarters 70 Stitch foxing 70 Stitch tips 70 Stitch quarters 70 Stit			56		
19 Fold saddle 58 Barring 20 Perforate quarters 59 Hand Trimming 21 Perforate vamps 60 Cement cushion soles 22 Perforate straps 61 Bind cushion soles 23 Perforate tips 62 Stitch covers 24 Perforate tips 63 Turn french cord 25 Stitch perforated quarters 26 Stitch perforated vamps 27 Stitch perforated tips vamp 28 Stitch perforated tips 64 Machine cut outs 29 Paste stickers 65 Button holes 30 Binding vamps 66 Sew buttons 31 Binding 53 Stitch quarters 33 Stitch vamps 54 Stitch foxing 55 Stitch tips			57		
20 Perforate quarters 59 Hand Trimming 21 Perforate vamps 60 Cement cushion soles 22 Perforate straps 61 Bind cushion soles 62 Stitch covers 62 Stitch perforated quarters 63 Turn french cord 70 Vamp					
21 Perforate vamps 22 Perforate straps 23 Perforate foxing 24 Perforate tips 25 Stitch perforated quarters 26 Stitch perforated vamps 27 Stitch perforated foxings 28 Stitch perforated tips 29 Paste stickers 30 Binding vamps 31 Binding 32 Stitch quarters 33 Stitch vamps 34 Stitch foxing 35 Stitch tips 36 Cement cushion soles 61 Bind cushion soles 62 Stitch covers 63 Turn french cord 7 vamp 7 vamp 8 dachine cut outs 7 and ends 8 Button holes 9 Button holes 9 Sew buttons 9 Stitch foxing 9 Stitch foxing 9 Stitch tips					
22 Perforate straps 23 Perforate foxing 24 Perforate tips 25 Stitch perforated quarters 26 Stitch perforated vamps 27 Stitch perforated foxings 28 Stitch perforated tips 29 Paste stickers 30 Binding vamps 31 Binding 32 Stitch quarters 33 Stitch vamps 34 Stitch foxing 35 Stitch tips					
23 Perforate foxing 24 Perforate tips 25 Stitch perforated quarters 26 Stitch perforated vamps 27 Stitch perforated foxings 28 Stitch perforated tips 29 Paste stickers 30 Binding vamps 31 Binding 32 Stitch quarters 33 Stitch vamps 34 Stitch foxing 35 Stitch tips					
25 Stitch perforated quarters 26 Stitch perforated vamps 27 Stitch perforated foxings 28 Stitch perforated tips 29 Paste stickers 30 Binding vamps 31 Binding 32 Stitch quarters 33 Stitch vamps 34 Stitch foxing 35 Stitch tips					
26 Stitch perforated vamps 27 Stitch perforated foxings 28 Stitch perforated tips 29 Paste stickers 30 Binding vamps 31 Binding 32 Stitch quarters 33 Stitch vamps 34 Stitch foxing 35 Stitch tips					
27 Stitch perforated foxings 28 Stitch perforated tips 29 Paste stickers 30 Binding vamps 31 Binding 32 Stitch quarters 33 Stitch vamps 34 Stitch foxing 35 Stitch tips		s	63	-a Turn french cord	
28 Stitch perforated tips and ends 29 Paste stickers 65 Button holes 30 Binding vamps 66 Sew buttons 31 Binding 32 Stitch quarters 33 Stitch vamps 34 Stitch foxing 35 Stitch tips					
29 Paste stickers					
30 Binding vamps 66 Sew buttons 31 Binding 32 Stitch quarters 33 Stitch vamps 34 Stitch foxing 35 Stitch tips					
31 Binding 32 Stitch quarters 33 Stitch vamps 34 Stitch foxing 35 Stitch tips					
32 Stitch quarters 33 Stitch vamps 34 Stitch foxing 35 Stitch tips			00	new buttons	****
33 Stitch vamps 34 Stitch foxing 35 Stitch tips					
34 Stitch foxing 35 Stitch tips					
35 Stitch tips					
36 Stitch goring					
	36 Stitch goring				

### FORM D4

### MAKING DEPARTMENT

	le	Patte	ern		Date	
Descri	pti	on				
		LASTING	Price			Pric
Op. #	1.	Getting last,			. Breasting	
		insole tacking		41.	Buffing shanks,	
	2.	Pasteing counter			wood heel	
	3.	Putting upper on las	t	42.	Cutting out for	
	4.	Cementing lining			wood heel	
	5.	Tacking counter to		43.	Tacking channel,	
		last			wood heel	
	6.	Pulling over		44.	Cementing channel	
		Pulling up right			breast of wood hee	el
		shoe		45.	Tempering breast	
	8.	Pulling up left		46.	Buffing breast on	
		shoe			wood heel	
	9.	H. M. Lasting		47.	Cutting off overlag	y
		No. 6 Lasting		48.	Cementing breast	
					piece	
				49.	Laying breast piec	e
					Cutting off side	
					breast	
				51.	Buffing breast and	
• • •					part sole	
		MAKING		52.	1st. scouring	
	16.	Wetting cloth shoes			Breast scouring	
	17.	Putting soil proof			Doping heels	
		on uppers			Edge trimming	
	18.	Tacking on covers			2nd. scouring	
	19.	Putting soil proof			Edge setting, wetti	
		on outsole		01.	& inking	0
	20.	Pulling tacks		59	Heel dyeing	
	21.	Pounding toe and			Heel inking	
		heel			Heel finishing, sea	+
	22	Bottom filler and		69.	wheeling	
		shank		21		
	92	Sole tacking			Buffing bottom	
					Naumkeag	
		Pulling 1st last		65.	Sanding sole at	
		McKay sewing		0.4	breast	
	40.	Cementing channel		64.	Brushing bottom	
	07	& wetting		65.	Cutting Shanks	
	21.	Closing channel,		66.	Staining bottom	
	00	sponge & level		67.	Inking shanks	
		Heel heat nailing			Hand Fudgeing	
		Sorting shoes			Wheeling shank	
		Levelling		70.	Wheeling sole at	
	31.	Cementing leather			breast	
	_	sole for Darex		71.	Beading	
	32.	Cementing Darex			Brush finishing	
		outsoles			Birding eye	
	33.	Laying Darex			Edge cleaning	
		outsole			Removing soil prod	of
	34.	Pricking heels				
		Heeling operation		76.	Pulling 2nd, last a	na
		Wetting lining, put	-		sort	
		ting in 2nd last		77.	Stamping forepart	
	37.	Relasting		78.	Stamping shank	
		Repulling last		79.	Stamping bunion	

### FORM D5

### FINISHING DEPARTMENT

Sample Description	Pattern		Date		
	Price				Price
Op.#86. Treein		Op. #95.	Singeing		
87. Polish	ing shoes	-	0 0		
	ng toe and heel	93.	Cutting lining	out corn	
89. Wetti	ng up cloth		mmig		
	ng felt for wood	94.	Cleaning		
heels			repairing		
	g for sock	96.	Dressing		
lining					
92. Sock 1	lining	97.	Ironing 1	inings	****
Date	FORM DEPARTME		TC	Model.	
Date	DEFARIME	NI COS	010	Model.	
Sample					
Description					
Description					
	Cutting	Dept.			
Op. No.					Price
1 Cutting out					
2 Second cutt 3 Dieing out	ing out				
4 Bal cloth lin	ninos				
	s, oxford, straps and	l pomps			
6 Vamp backe		L			
6-a Quarter ba					
7 Bal, and lac					
8 Leather lini 9 Linings, oxf				*****	
	ford and pomp igue and extra strap	· .			
11 Socks by ha					
				****	
			Piece		
			Less		
			TOTAL	-	

### Fitting Dept.

1 Inking	
2 Marking	
2-a Marking	
3 Skive lining back seam	
7-c Reinforce tongues	
7-0 Reinforce upper	
8 Skiving sample no.	*******
9 Closing sample no.	
9-a Closing foxing	
9-b Closing vamp	
10 Staying sample no.	
11 Rubbing seam	
12 Clip edge	
12-a Clip edge	
13 Fold quarters	
14 Fold vamps	
15 Fold straps	
16 Fold foxings	
17 Fold tip	
18 Fold tongue	********
19 Fold saddle	
20 Perforate quarters	
21 Perforate vamps	
22 Perforate straps	
23 Perforate foxing	
24 Perforate tips	
25 Stitch perforated quarters	********
26 Stitch perforated vamps	
27 Stitch perforated foxings	
28 Stitch perforated tips	
29 Paste stickers	
30 Binding vamps	
31 Binding	
32 Stitch quarters	
33 Stitch vamps	
34 Stitch foxing	
35 Stitch tips	
36 Stitch goring	
37 Stitch saddle	
38 Under or overlay on quarter	
29 Under or overlay on vamp	
40 Stitch tongue	
41 Stitch straps	
42 Stitch cut-outs	* * * * * * * * * *
43 Stitch die cut-outs	
44 Crease vamps	********
45 Vamp circular vamp	
46 Vamp pomps	
47 Vamp blucher oxfords	
48 Undertrim and edgestitch	
49 Undertrim oxfords	*******
50 Undertrim blucher oxfords	
51 Undertrim bals	**********
52 Undertrim blucher vamp	

	No.		Price
53 54	Eyeletting Lining tongues		
55	Toe seaming		
56	Stitch tongue to lining		
57	Lacing		
58	Barring		
59	Hand Trimming		
60	Cement cushion soles		
61	Bind cushion soles		
62	Stitch covers		
63	Turn french cord		*********
64	a Turn french cord vamp Machine cut outs and ends		
65	Button holes		
66	Sew buttons		
00	DOTT DEPOTED		
		Piece	
		Fiece	
		Less	
		TOTAL	
		IOIAL	
	Lasting Dept.		
1	Getting last, tacking insole		
2	Pasting counter		
3	Putting upper on last		
	Wetting lining		
4	Cementing lining		
5	Tacking counter to last		
6	Pulling over	×	
8	Pulling up right shoe Pulling up left shoe		
9	H. M. lasting		
10	No. 6 lasting		
	and a second		
		Diago	**********
		Piece	
		Less	
		TOTAL	-
		TOTAL	

### Making Dept. Price Op. No. 16 Wetting cloth shoes 18 Tacking on covers 19 Putting soil proof on outsole 20 Pulling tacks 20-a Trim out lasting 21 Pounding toe and heel 22 Bottom filler and shank 23 Sole tacking 23-a Wet up channel 23-b Open channel 24 Pulling 1st last 25 McKay sewing 26 Cementing channel and wetting 27 Closing channel, sponge and level 28 Heel seat nailing 29 Sorting shoes 30 Levelling Cementing leather sole for Darex 31 32 Cementing Darex outsoles Pricking heels 34 36 Wetting lining, putting in 2nd last 37 Relasting Repulling last 39 Heel trimming 40 Breasting Buffing shanks, wood heel 41 Cutting out for wood heel 42 Tacking channel wood heel 43 44. Cementing channel at breast of wood heel 45 Tempering breast 46 Buffing breast on wood heel Cutting off overlay 47 48 Cementing breast piece 49 Laying breast piece 50 Cutting off side breast 51 Buffing breast and part sole 52 1st Scouring 53 Breast scouring 54 Doping heels 55 Edge trimming 2nd scouring Edge setting, wetting 57-a Inking edges 58 Heel dyeing Heel inking 59 Heel finishing, seat wheeling 67 Buffing bottom 62 Naumkeag 63 Sanding sole at breast 64 Brushing bottom 65 Cutting shanks Staining bottom

67

Inking shanks 68 Hand fudging

Op. 69 70 71 72 73 74 75 76 77 78 79 80	No. Wheeling shank Wheeling sole at breast Beading Brush finishing Birding eye Edge cleaning Removing soil proof Pulling 2nd last and sort Stamping forepart Stamping shank Stamping bunion Polishing heels		Price
		Piece Less TOTAL	
	Finishing Dept.		
95 96	Treeing Treeing toe and heel Polishing shoes Wetting up cloth shoes Sticking felt for wood heels Sorting for sock lining Sock lining Cutting out corner lining Cleaning and repairing Singeing Dressing Ironing linings	Piece	
		Less	
	Department Labor Rec	TOTAL	
	Department Labor Reca	spituiation	

PIECE TIME DEPT. LABOR

CUTTING FITTING SOLE LASTING MAKING FINISHING

Total Departmental Cost

### FORM D7

MODEL ......PATTERN .....SAMPLE .....

DESCRIPTION ......

OLD No.....LAST No....LAST....DATE.....

ITEMS Material Test Cost Extension Quarter Vamp Fox Tip Back Strap Straps Overlays Eyelet Stay Saddle Collar Throat Insert Tongue Top Band Heel Covers Sheep Facing Heel Pad Felt

Quarter Lining Sock Lining Tongue Lining Cloth Lining

Plumping

Cloth Covering

Backing Oilcloth Stafast Black Stafast White Backing Back Seam Goring

Trimming
Binding
Royalty (Fitting)
Thread (Fitting)
Eyelets
Butts, Buckles
Stay Tape
Gum Tape

ITEMS Material Cost Extension

Outsole Rivet Insole Fibre Cookie

Counter Box Toe Staples Lasting Tacks

Filler Shanks Scotch Tape

Thread (McKay) Wax (McKay)

Heel Top Lift

Nails Heel Nails Loose

Cement

Embossing Leaf

Royalty (Making)

Laces

Ornaments

Sticks

1

Cartons, Cases, &c.

TOTALS

SUMMARY 1st Column Total 2nd Column Total

**Material Cost** 

No. 1 No. 2 Cutting No. 3 Fitting Cost Sole Room Lasting Cost Making Cost Treeing Cost Making & Material

Overhead Net Total

Add

TOTAL Nett

Date Cancelled

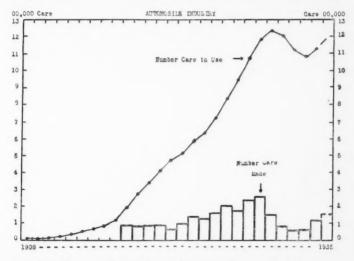
### MOTOR INDUSTRY

### MOTOR INDUSTRY LEADS RECOVERY

Its Return to Normal Volume Should be Followed by Spread of New Buying Power to Other Lines—General Volume of Business Keeps Ahead.

### By W. A. McKAGUE

Of all the major lines, the automobile industry is enjoying the most rapid recovery, according to current statistics. In the first seven months of 1935, more cars were made in Canada than in the whole of 1934, and figures which are available for actual sales make a similar showing. At this rate, the year's total should reach 155,000 cars, which would be higher than in any previous year outside of the 1925-29 period, which set the high record, culminating in the total of 262,625 cars in 1929. The year 1930 brought a sharp reach 155,000 cars, which would be higher than in any previous year



exceeded this year if the industry keeps up its present pace.

Other industries not so fortunate may be envious of this apparent concentration of buying power in motor-cars, but from a longer viewpoint the news is good. It definitely shows that public purchasing power is enlarged. When the accumulated demand for cars becomes more or less satisfied, it is logical to expect buying to turn to other lines. What is most likely is that buying will broaden and benefit other industries, while the trend in automobiles at the same time continues upward.

This stimulus in the automobile industry is not peculiar to Canada. In the United States also, more cars were made and sold in the first seven months of this year than in the whole of last year. While

much below its previous peak, the industry is back to a long-term average or normal. It has been the most active buyer of supplies from the iron and steel industries, thus spreading purchasing power

and employment through these channels.

It must be remembered that the motor industry is still young. It was taking a more and more important place each year both in production and in the consumer's budget, until checked by the depression's severity. The number of cars licensed or in use in Canada climbed without a break from nominal figures before 1910 to 1,232,000 in 1930. It declined to 1,083,000 in 1933, but recovered to 1,129,500 in 1934, and, on the basis of production and sales, should be back to about 1.200,000 this year. The number of cars made has of course fluctuated more sharply, the low being 60,789 in 1932. Export business swelled the total in the boom years, and it is a factor in the current recovery; this means more buying power to the credit

of Canadian producers.

While outstanding in its size, the automobile industry is not by any means enjoying a monopoly of buyers' attention. There are devices even newer than the motor-car. Electric refrigeration, developed on the eve of the depression, gained rapidly in spite of the times. Radios, though widely distributed by 1929, are making a rapid come-back in sales. It is not possible to say how near 1,200,000 motor-cars and about 1,000,000 radios are to a state of mature development for Canada's population, but it is certain that when people have spent some money getting up-to-date on these devices which have been improved so much in late years, they will turn more attention to other comforts and luxuries—good food products, clothing, and furniture. Even now, substantial gains in business are being experienced by manufacturers and distributors of stoves, of carpets, and of many other kinds of goods which have come into demand because of merely normal wear and tear in use.

Regardless of how it may be divided, the total business of the country is growing. Total money turnover this year to date is about six per cent. ahead of the same part of 1934. Railway traffic is a little ahead, and the average production of all industries shows a fair gain. Political uncertainties continue the chief handicap, but in spite of this, employment and buying power are being slowly

enlarged.

In a certain English town there is a row of houses which has a road at the back as well as at the front. One dark night a man went to call on a friend who lodged in one of the houses in this row. Being unfamiliar with the place, the caller went to the back door, which was opened by a maid.

"Is Mr. So-and-So in?" asked the visitor, to which the girl replied reprovingly, "This is the back door, sir. You must go round

to the front."

Round to the front—and it was some distance round—went the would-be caller, and rang the bell. The door was opened by the same maid, who waited for him to ask the customary question, "Is Mr. So-and-So in this evening?"

To which the girl replied, "No, sir, he's out."

### FINANCIAL STATEMENT

### FINANCIAL STATEMENT

### THE CANADIAN SOCIETY OF COST ACCOUNTANTS &

### INDUSTRIAL ENGINEERS

### BALANCE SHEET

APRIL 30. 1935

### ASSETS

		469.35 ,492.95 18.75
	\$3	,981.05
	\$	62.50
\$3,738.32 82.50 71.03 26.70	3	3,918.55
	82.50 71.03	\$3,738.32 \$2,50 71.03 26.70

### Examined and found correct.

C. H. PELLING, C.A. FRED PAGE HIGGINS, C.A. \$3,981.05

Toronto. August 28, 1935.

### STATEMENT OF REVENUE AND EXPENDITURES FOR THE YEAR ENDED APRIL 30, 1935

Revenue Membership Fees Collected Interest Earned Publications Revenue Examination Fees	\$4,432.55 175.00 243,08 90.00
	\$4,9b0.63
Expenditures	
General Expenses	\$1,753.63
Chapter Allowances	1,335.54
Publications Expense	1,801.43
Bank Exchange	23.33
Surplus for the Year	26.70
	\$4,9b0.63

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